

Date: Tuesday, 10/06/2008 3:14:26 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: "T" HANDLE ASSEMBLY
<b>Job Number</b>	: 39802		
<b>Estimate Number</b>	: 11179		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2282041
<b>This Issue</b>	: 10/06/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2282 REV E
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38606A	<b>Drawing Revision</b>	: E
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JLD 08 6-10</u>	<b>Due Date</b>	: 30/06/2008
<b>Comment</b>	: Est Rev:A Removed from 9 Digit 05-12-02 JLM	<b>Qty:</b>	50 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D22823	Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-3	Handle tube	9X B35472
		41X B38640

(50)

EL 8-8-5

2.0	D22825	Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-5	Handle tube	50X B38641

(50)

EL 8-8-5

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.as per dwg D2282

\*\*\*\*\*brush weld right after welding, to take color off \*\*\*\*\*

A/R	ER316L SS	Filling Rod	M101744
		Dwg Rev:	E

(50)

EL 8-8-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 3:14:27 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 39802

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 0808-21 (50)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

5/9/12  
Ball welded mark +  
Tumble

08/08/12 50 thn

SB 08/08/21 (50)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/21 (50) centered

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

1/1

08.08.21 50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



mf 08-08-21

30

**Dart Aerospace Ltd**

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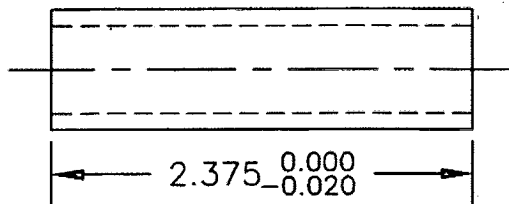
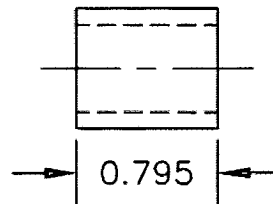
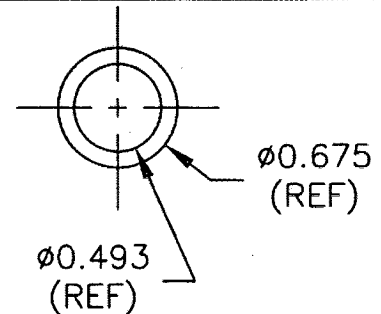
**NOTE:** Date & initial all entries

**DART**

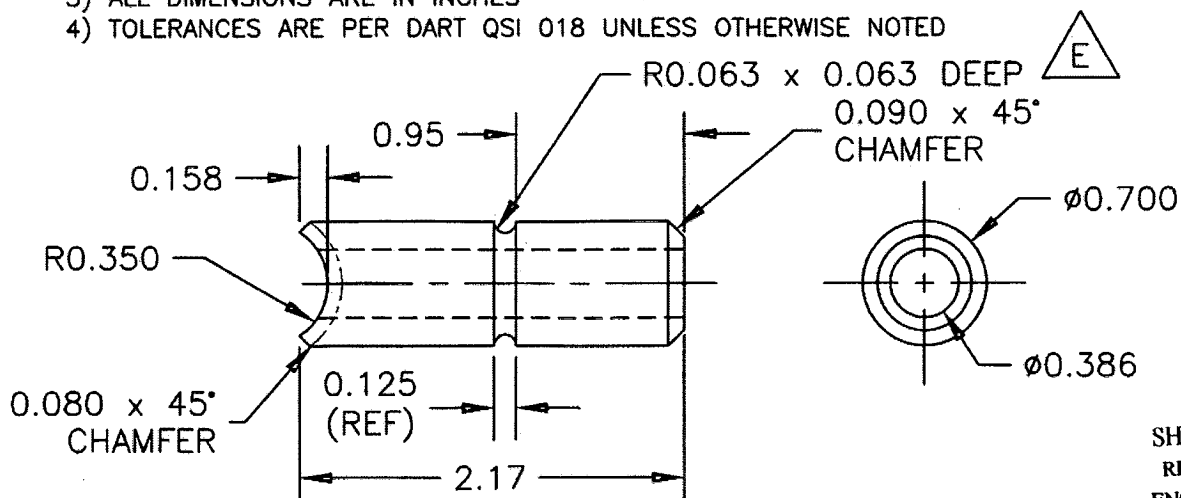
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**RELEASED**

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



NO. 37802

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

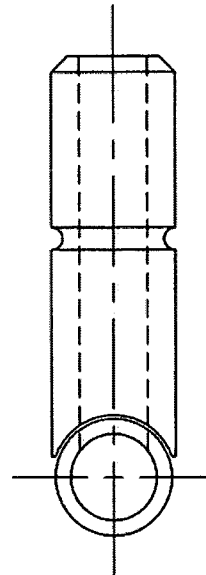
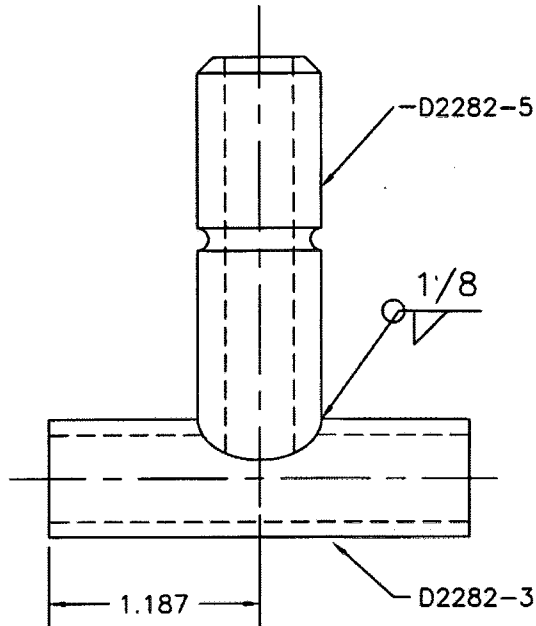
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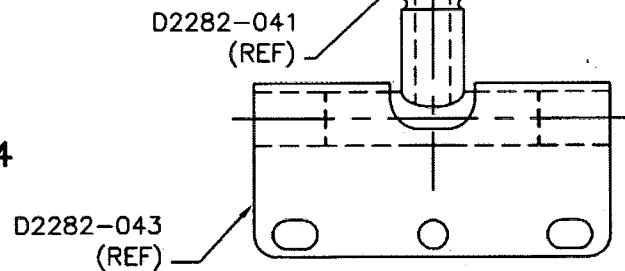
**DART**

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES SCALE 1:1	

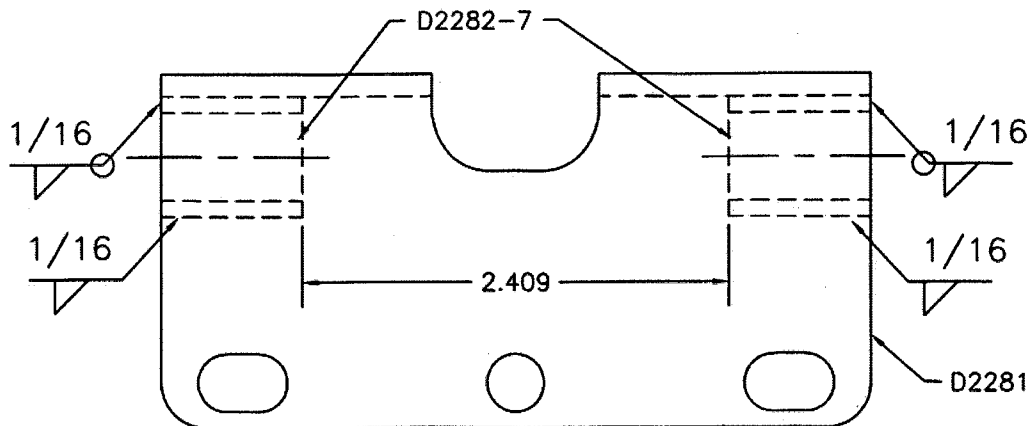


**RELEASED**  
*[Signature]*  
05/09/16

**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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